

Work Order ID 65193

Friday, January 07, 2011 10:40:52 AM



Page 1

Item ID: D3508-9

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 1/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

1/1-01-7

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3508

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3508 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
Deburr if necessary

304 . 040

BIL-1-10

(6)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

BIL-1-10

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Silvio

x6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Friday, January 07, 2011 10:40:52 AM

Page 2

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

0.00

Brake NC

Memo

0.00

Brake NC

Deburr and form on brake using DT8326 and DT8261 as per Dwg D3508

avg D3508
SB 11/01/11

QC5- Inspect part completeness to step on W/O

0.00

Abstract

OC

Memo

0.00

Quality Control

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

11-11-11

Powdercoat

Memo

0.00

Powder Coating

START TIME: 11:25 ☐ OVEN TEMPERATURE:

FINISH TIME: 10:55

W/O:		WORK ORDER CHANGES					
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Work Order ID 65193

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Page 3

Item ID: D3508-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 1/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 <i>all</i> 0.00				<i>x6</i>	<i>0</i>	<i>all</i>	<i>u/s + 1</i>
170 Packaging Packaging	Identify as per dwg & Stock Location: <i>F12-21</i> Memo	0.00 0.00				<i>x6</i>	<i>0</i>	<i>all</i>	<i>u/s + 1</i>
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>11/01/12</i> <i>MF</i> <i>61-01-11</i>

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, January 07, 2011 10:40:56 AM

Page 1

Work Order ID: 65193

Parent Item: D3508-9

Parent Item Name: Wearplate



Start Date: 1/7/2011

Required Date: 1/14/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07.06.12 EC
IPP Rev:B Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	181.0714	0.417	2.633684			



304/316 .040 Sheet



181-1-10

Location	Loc Qty	Loc Code
MAT	178.3	
115762	10.2	
115953	11.1	
116437	157	
MAT20	2.7714	
113062	1.398	
115440	1.3734	

116437

(6)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	65193
Description: Wearplate		Part Number:	D3508-9
Inspection Dwg: D3508 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.063	+/-0.010	2.066	X		V HB2	
2.813	+/-0.010	2.811	X		V	
0.375	+/-0.010	.373	X		V	
2.90	+/-0.030	2.90	X		V	
5.800	+/-0.010	5.800	L		T HB1	
11.600	+/-0.010	11.600	B		T	
17.400	+/-0.010	17.400	B		T	
Ø0.188	+0.005/-0.001	.192	X		V	
0.300	+/-0.010	.305	X		V	
0.300	+/-0.010	.303	X		V	
0.038	+/-0.010	.036	X		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 11-1-10	Date: 11/01/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.07.24	New Issue	KJ/DD	AS

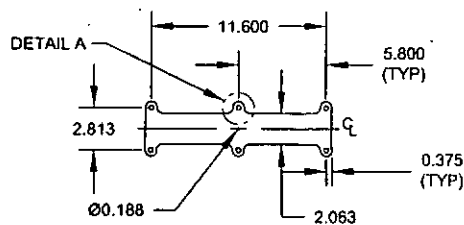
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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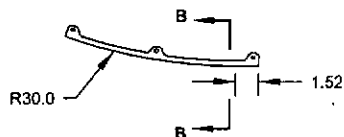
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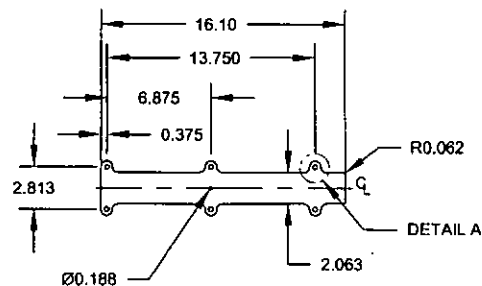
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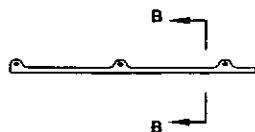
D3508-1 FLAT PATTERN



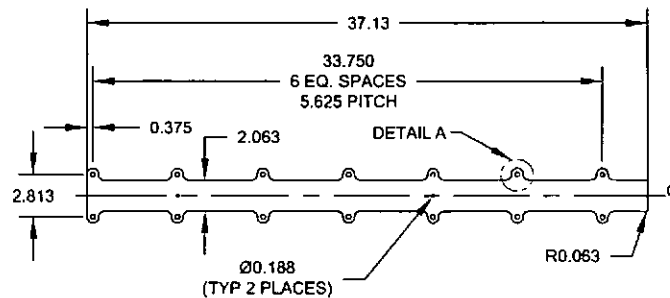
D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)



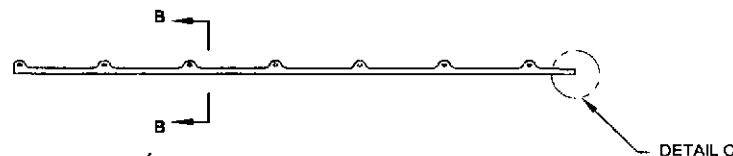
D3508-7F FLAT PATTERN



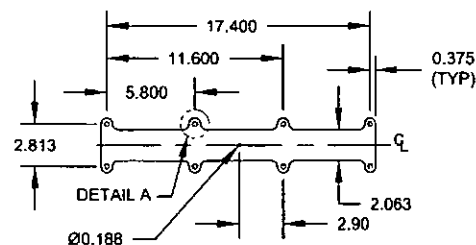
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(MAKE FROM D3508-7F)



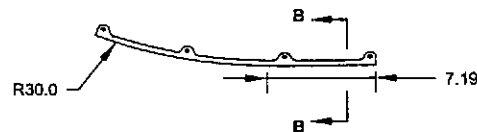
D3508-3 FLAT PATTERN



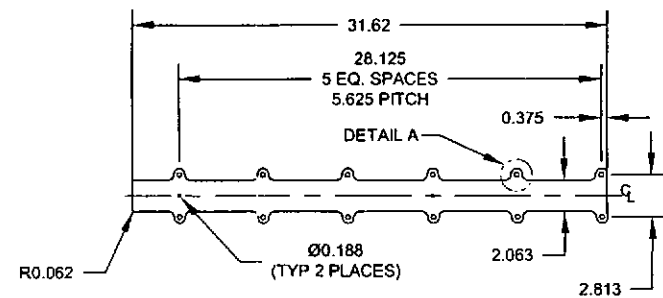
D3508-3 BENDING DETAIL
(MAKE FROM D3508-3F)



D3508-9F FLAT PATTERN



D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)



D3508-5 FLAT PATTERN



D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs,
D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs
D3508-13 - 0.25 lbs

RELEASED
07-11-16

C	ADD -9/11/13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE USA, INC	
DRAWN	<i>[Signature]</i>	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3508	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE	1:8
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION FROM DART AEROSPACE USA, INC.	

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65193

2/11-01-7

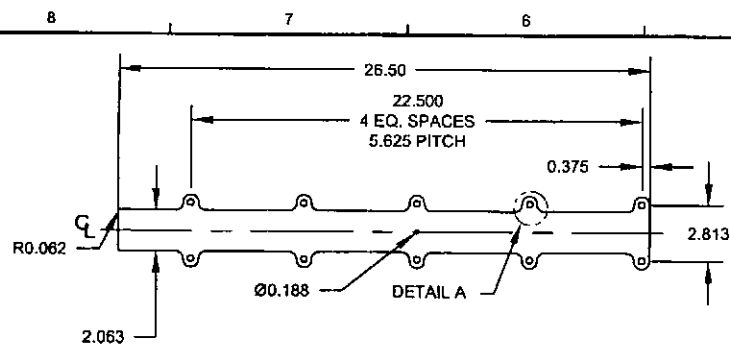
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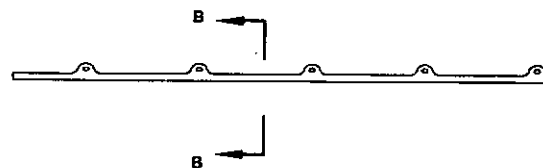
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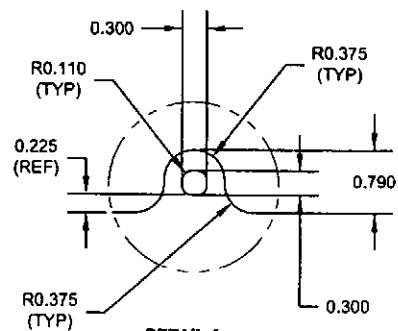
NOTE: Date & initial all entries



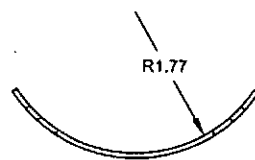
D3508-11F FLAT PATTERN



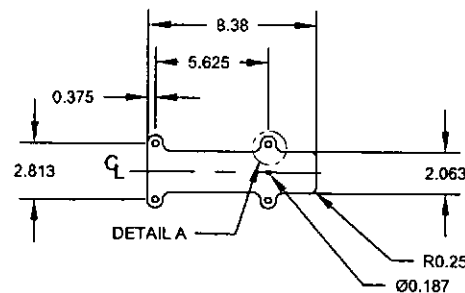
D3508-11 BENDING DETAIL
(MAKE FROM D3508-11F)



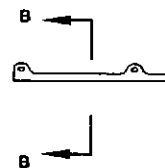
DETAIL A
(SCALE 2:3)



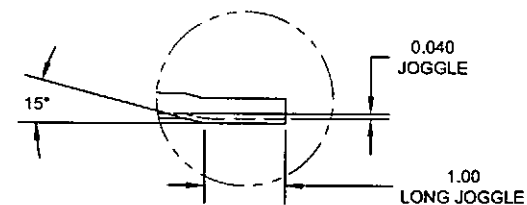
SECTION B-B
(SCALE 2:3)



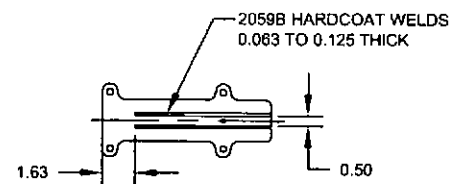
D3508-13F FLAT PATTERN



D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)



DETAIL C
(SCALE 1:2)



D3508-13 WELDING DETAIL

RELEASED
07/11/93

w/1065193

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3508	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARPLATE	1:6
DATE	07.04.20	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR COMMUNICATION TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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